

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000346**Date Inspected:** 03-Aug-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wenhui Xiong**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:****Summary of Items Observed:**

The CALTRANS Quality Assurance (QA) Inspector, Alfredo Acuna was present for the ZPMC visual inspection (with a 5x magnified glass) and magnetic particle testing (MT) after the cold bent steel plate trial for the orthotropic deck, close ribs # 7, 8 and 9 designated as V101, V103 and V105 respectively. The testing was at the OBG ZPMC fabrication facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge. The QA Inspector observed that the testing was performed by approved ZPMC QC MT ASNT level II, Cai Xinxin. Mr. Cai was following the AWS D1.5, Section 6 requirements. ABF representatives Kevin Carpenter, Peter Ferguson, Warren Buehler, ZPMC representative, Xu Jun and Shen Xue Jun, and Caltrans Task Leader Robert Cuellar were present during the trial. The QA inspector observed that the MT and visual examinations appeared to be in compliance with contract documents. The QA inspector selected randomly 5 areas for Caltrans destructive testing (macroetch testing on the cutting edges) on the above mentioned close ribs as required per the special Provisions.

ZPMC at the end of the shift had not completed the MT verifications. The QA inspector had a conversation with Mr. Ferguson and Mr. Buehler. ABF representatives relayed to the QA inspector that ZPMC planned to cut the test samples over the weekend and completed the MT verifications and visual inspections to the areas selected by Caltrans.

The photos below show ZPMC performing MT and visual examinations with the 5x magnification glass on the bending close rib trial.

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Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Acuna,Alfredo

Quality Assurance Inspector

Reviewed By: McClary,David

QA Reviewer